



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
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Canada

Tel (613) 632-5200
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D117-762-041
Job Sheet 201676



Part No: D117-762-041

Job Qty: 1 pcs

Part Name: Replacement Skidtube



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/8/19

Job Tracking No:

Due Date: 10/29/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D3582 REV E IPP Rev:A 07.06.11 New Issue EC IPP Rev:B 08-02-22 change to revA as per dwg DD
verF by:EC IPP REV:C 15.06.11 AS PER CHG002 DD VERF:JLM IPP REV:D 16.02.05 DWG REV.C (ecn16-
514)DD VERF:JLM IPP REV:E 17.01.17 as per dwg REV.D DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Run Hrs Hrs	Workcenter/Supplier		Sign-off
						Workcenter / Supplier	Lead Time	
130	Skidtubes - 1	1 pcs	10/29/19		0.00 3.30 4.88	Skidtubes - 1		[Signature]
						Skidtubes - 2		
						Skidtubes - 3		
						Skidtubes - 4		
						Skidtubes - 5		
						Skidtubes - 6		
						Skidtubes - 7		
140	Skidtubes - 2 - B4B	1 pcs	10/29/19		0.00 3.30 1 HR 05	Skidtubes - 1 - B4B		[Signature]
						Skidtubes - 2 - B4B		
						Skidtubes - 3 - B4B		
						Skidtubes - 4 - B4B		
						Skidtubes - 5 - B4B		
						Skidtubes - 6 - B4B		
						Skidtubes - 7 - B4B		
150	QC 10	1 pcs	10/29/19		0.00 0.00	QC 10 - 10		[Signature] DAS OCT 21 2019 5:58 9-89
						QC 10 - 18		
						QC 10 - 24		
						QC 10 - 43		
						QC 10 - 50		
						QC 10 - 58		
						QC 10 - 9		
160	QC 5	1 pcs	10/29/19		0.00 0.00	QC 10 - 68		
						QC 5 - 10		
						QC 5 - 12		
						QC 5 - 17		
						QC 5 - 18		
						QC 5 - 19		
						QC 5 - 22		
						QC 5 - 24		
						QC 5 - 3		

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					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	OCT 21 2019 DAS 68
					QC 5 - 9	9-89
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
170 Handfinish - 1-1 Chemical-B4B	1 pcs	10/29/19	0.00	0.97	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	OCT 22 2019
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
180 QC 7	1 pcs	10/29/19	0.00	0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	

				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	
				QC 7 - 76	
				QC 7 - 79	
190 Skidtubes - 3 - B4B	1 pcs	10/29/19	0.00 3.33	Skidtubes - 1 - B4B	BB
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	BE
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
200 QC 10	1 pcs	10/29/19	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	
				QC 10 - 50	
				QC 10 - 58	
				QC 10 - 9	
				QC 10 - 68	
210 QC 5	1 pcs	10/29/19	0.00 0.00	QC 5 - 10	DAS OCT 28 2019 68 9-89
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
215 Handfinish - 2-1 Pressure-	1	10/29/19	0.00 0.97	Handfinish - 2 - 1 -	

B4B				pcs				B4B	
								Handfinish - 2 - 2 - B4B	★ OCT 29 2019
								Handfinish - 2 - 3 - B4B	
								Handfinish - 2 - 4 - B4B	
220	Powdercoat - 1 White GI(A)-B4B	1	10/29/19	0.00	0.26	Powdercoat - 1 - B4B		Powdercoat - 2 - B4B	
								Powdercoat - 3 - B4B	BL 19-10-29
								Powdercoat - 4 - B4B	
								QC 3 - 10	
								QC 3 - 13	
								QC 3 - 15	AL 19-10-30
								QC 3 - 17	
								QC 3 - 18	
								QC 3 - 2	
								QC 3 - 28	
								QC 3 - 3	
								QC 3 - 30	
								QC 3 - 34	
								QC 3 - 36	
								QC 3 - 41	
								QC 3 - 51	
								QC 3 - 58	
								QC 3 - 59	
								QC 3 - 68	
								QC 3 - 9	
								QC 3 - 40	
								QC 3 - 19	
								QC 3 - 43	
								QC 3 - 24	
								QC 3 - 61	
								QC 3 - 81	
250	Handfinish - 4-1-Assembly-B4B	1	10/29/19	0.00	0.97	Handfinish - 4 - 1 - B4B		Handfinish - 4 - 10 - B4B	AL 19-11-01
								Handfinish - 4 - 11 - B4B	
								Handfinish - 4 - 12 - B4B	
								Handfinish - 4 - 13 - B4B	
								Handfinish - 4 - 14 - B4B	
								Handfinish - 4 - 15 - B4B	
								Handfinish - 4 - 2 - B4B	
								Handfinish - 4 - 3 - B4B	
								Handfinish - 4 - 4 - B4B	
								Handfinish - 4 - 5 - B4B	
								Handfinish - 4 - 6 - B4B	
								Handfinish - 4 - 7 - B4B	
								Handfinish - 4 - 8 - B4B	

DAS
15
9-89

10/8/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

				Handfinish - 4 - 9 - B4B	
260 QC 5	1 pcs	10/29/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
270 Packaging 3-1 - Stock - B4B	1 pcs	10/29/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
275 DC - 1 - B4B	1 pcs	10/29/19	0.00 0.00	DC - 1 - B4B	
				DC - 2 - B4B	

DAS
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9-89

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NOV 0 7 2019

DAS
21
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NOV 0 7 2019

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280 QC 21 - FG

1
pcs

10/29/19

0.00 0.00

QC 21 - FG - 21

21

NOV 07 2019

QC 21 - FG - 70

QC 21 - SA - 53

Part Op 130 - Skid tubes-1 (Skid tubes) 1-Cut Aft end using DT8185 2-Deburr ends 3-Drill Aft Cap holes using DT8678 *** OPEN
 Descriptions: AFT CAP HOLE TO .187" *** 4-Locate DT 8973 from aft cap holes & Drill Ground wire hole on top of Tube. 5-Install 3/16
 cleco in Ground wire hole ,then drill all X-Bolt holes using 3/16" drill. 6-Drill pilot holes for wearplates using DT8900 7-
 Open wearplate holes to Ø19/64" (0.297") as per Dwg D3582. 8-Drill holes for D5520-1 doubler using DT10309 A & B,
 locating from 4th and 5th crossbolt holes from aft using .1875 clekos. Spot drill tube using #20 drill (note 10). Remove
 DT10309 B. Re-install DT 10309 A drill thru tube and doubler using #20 drill (note 10), cleco as you go. Remove .1875
 clekos and open holes in tube and doubler to 0.750". Remove doublers and identify orientation. 9-Deburr doubler and
 doubler holes in skid tube. 10-Countersink doubler holes in skid tube as per Dwg. detail J and note 12 -Touch up alodine
 on D5520-1 doublers. 11- open ground wear holes to 0.391" as per section B-B 12-Open Aft Cap holes using .209" drill.
 13-Drill pilot holes for section D-D and E-E. Holes must be laid out by hand. Mark out Center line and make sure that 6.65
 and 5.906 measurements are respected. Double check before drilling, do not open holes to finish size. 12-Do not open
 holes of section G-G to finishes size.

140 - Skid tubes-1 (Skid tubes) 1-Weld fwd cap D2964 per dwg D3582 and QSI 004 A/R AL ROD

Batch: 130907/139011 2-Grind flush

150 - QC10 (QC10- Inspect visual per QSI004- ground welds)

160 - QC5 (QC5- Inspect part completeness to step on W/O)

170 - HandFinish1 (Chemical Conversion Coat per QSI005 4.1)

180 - QC7-1 (QC7-Inspect Chemical Conversion Coat)

190 - Skid tubes-1 (Skid tubes) ***MASK OFF HOLES OF SECTION F-F (DO NOT C'SINK) 1-Open X-Bolt holes to finish
 size as per Dwg D3582, sections D-D, E-E, G-G as per Dwg. 2-Counter Sink X-BOLT holes as per Dwg D3582 D-D, E-E
 and G-G. ***Do NOT countersink holes of section F-F). 3-Deburr and blow out chips from inside of tube, prep. tube for
 welding. 4-Install doublers using DT10309 B. Shave rivets as required. 5-Bond web as per Dwg D3582 & QSI 015 A/R

241 Sika Flex Batch: 5206675 Exp Date: 30-7-27 6- Swage x-bolt spacer as per dwg and
 Section F-F QSI002. 7-Weld x-bolt spacers as per Dwg D3582 section D-D, E-E and G-G. A/R AL ROD

Batch: 8-Grind welds flush

200 - QC10 (QC10- Inspect visual per QSI004- ground welds)

210 - (QC5- Inspect part completeness to step on W/O)

215 - HandFinish2 (Pressure Wash per QSI005 4.3/ Clean and remove all markings) Touch-up alodine as per QSI

220 - Powdercoat1 (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME _____ OVEN TEMPERATURE:
 FINISH TIME: _____

230 - (QC3- Inspect Part Finish)

250 - HandFinish4 (Assemble as per dwg) 1-Inspect for Foreign objects 2-Install Aft cap as per Dwg D3582, Detail "C"
 A/R 241 Sika Flex Batch: 5206675 Exp Date: 30-7-27 3-Install Wearplates as per Dwg D3582 ,
 Note:Install Bolt and washer on Ground Wire inserts on top of tube see section D-D of dwg D3582 *****Do not install
 bolts where indicated on Dwg(Note #6)***** 4- Wing Walk as per Dwg D3582 and QSI 005 4.4

260 - (QC5- Inspect part completeness to step on W/O)

270 - Identify and pack for shipping as per PPP D117-762-041 Location :FG081

275 - (Document Control) Photocopy bluefile & type labels per PPP D117-762-041 CHG003

280 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3582-1-BENT	Skidtube Assembly BK117	1 pcs (1 ea)	130-Skidtubes - 1	5207225
D5520-1	Doubler	2 pcs (2 ea)	130-Skidtubes - 1	5218123
D2964	Cap	1 pcs (1 ea)	140-Skidtubes - 2 - B4B	5746303
CR3212-5-05	Rivet	69 68 pcs (68 ea)	190-Skidtubes - 3 - B4B	5214469
D2971	Cross Bolt Spacer	1 pcs (1 ea)	190-Skidtubes - 3 - B4B	5097024
D3584-1	Web	1 pcs (1 ea)	190-Skidtubes - 3 - B4B	5174775
D3662-1	Crossbolt Spacer	3 pcs (3 ea)	190-Skidtubes - 3 - B4B	5173644
D3662-3	Crossbolt Spacer	1 pcs (1 ea)	190-Skidtubes - 3 - B4B	F81600
D5304-1	Crossbolt Spacer	2 pcs (2 ea)	190-Skidtubes - 3 - B4B	216385
ALS4-1032-130	Rivnut	36 Ea (36 ea)	250-Handfinish - 4-1-Assembly-B4B	5057257
ALS4-428-165	Insert	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B	5147561
AN3-5A	Bolt	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B	5216385
AN3C4A	Bolt	28 Ea (28 ea)	250-Handfinish - 4-1-Assembly-B4B	522531468
AN4-4A	Bolt	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B	5193116
D2965	Cap	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	5166570
D3508-11	Wearplate Aft Center	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	5146352
D3508-13	Wearplate Aft	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	5172983
D3508-3	Wearplate Fwd Center	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	5172626
D3508-9	Wearplate Fwd	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	5172937
D3558-11	Gasket Aft Center	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	5216680
D3558-13	Gasket Aft	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	5224210
D3558-3	Gasket Center Fwd	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	5216681
D3558-9	Gasket Fwd	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	5216682
NAS1149C0332R	Washer (AN960C10L)	28 Ea (28 ea)	250-Handfinish - 4-1-Assembly-B4B	5218151
NAS1149D0332J	Washer	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B	5198378
NAS1149D0416J	Washer	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B	FM131011

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
130-Skidtubes - 1	D3582-1-BENT	1	3	0
	D5520-1	2	42	0
140-Skidtubes - 2 - B4B	D2964	1	22	0
190-Skidtubes - 3 - B4B	CR3212-5-05	68	444	0
	D2971	1	63	0
	D3584-1	1	5	0
	D3662-1	3	119	0
	D3662-3	1	36	0
	D5304-1	2	37	0
250-Handfinish - 4-1-Assembly-B4B	ALS4-1032-130	36	5,708	0
	ALS4-428-165	2	68	0
	AN3-5A	2	266	0
	AN3C4A	28	1,464	0
	AN4-4A	2	37	0
	D2965	1	50	0
	D3508-11	1	11	0
	D3508-13	1	7	0
	D3508-3	1	14	0
	D3508-9	1	12	0
	D3558-11	1	11	0
	D3558-13	1	3	0
	D3558-3	1	12	0
	D3558-9	1	12	0
	NAS1149C0332R	28	3,974	0
	NAS1149D0332J	2	1,265	0
	NAS1149D0416J	2	1,739	0

Part Specifications

Specifications could not be found.

ITEM	Qty	Part Number	Description
	X	D3682-041	SKIDTUBE ASSEMBLY
1	1	D2882-150	EXTRUSION
2	1	D2884	CAP
3	1	D2885	CAP
4	1	D2871	CROSS BOLT SPACER
5	1	D3508-3	WEARPLATE
6	1	D3508-9	WEARPLATE
7	1	D3508-11	WEARPLATE
8	1	D3508-13	WEARPLATE
9	1	D3558-3	GASKET
10	1	D3558-9	GASKET
11	1	D3558-11	GASKET
12	1	D3558-13	GASKET
13	1	D3684-1	WEB
14	3	D3682-1	CROSS BOLT SPACER
15	1	D3682-3	CROSS BOLT SPACER
16	2	D5304-1	CROSS BOLT SPACER
17	2	D5520-1	DOUBLER
18	28	AN3C4A	BOLT
19	2	AN3-5A	BOLT
20	2	AN4-4A	BOLT
21	28	NAS1148D0332R	WASHER (AN880C10L)
22	2	NAS1148D0332J	WASHER (AN880JD10L)
23	2	NAS1148D0416J	WASHER (AN880JD416L)
24	38	AELS-1032-130	INSERT
25	2	ALST-428-165	INSERT
26	68	CR3212-5-06	CSK RIVET, CHERRY MAX

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1 PRIOR TO INSERTING D3684-1 WEB. POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.4.1) PER DART QSI 005 4.3.
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 18.2 LBS
 - 8) WELDING: PER DART QSI 004.
 - 9) INSERT D3684-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/281 ADHESIVE PER DART QSI 018 AFTER BENDING.
 - 10) USE DART DRILL TEMPLATE DT8900 TO LOCATE AND DRILL Ø0.287 HOLES (38 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION G-G (38 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/281.
 - 11) DO NOT INSTALL AN3C4A BOLTS AND NAS1148D0332R WASHERS IN INDICATED LOCATIONS
 - 12) LOCATE QTY (34) HOLES ONTO THE SKIDTUBE PER D5520-1 DOUBLER AND DRILL Ø0.161 THRU SKIDTUBE AND DOUBLER USING DT10308. COUNTERSINK Ø0.286 x 100° (34 PL) PER DOUBLER AND INSTALL EACH D5520-1 DOUBLER USING QTY (34) CR3212-5-06 CSK RIVETS.

RELEASED
2017-10-11
2017-547

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 2016-16 MWS
19-10-08

E	MOVE VIEWS FROM SHT 1 TO SHT 2. ADD ITEMS 17 & 28 AND NOTE 12-13. Ø0.167 HOLE WAS Ø0.175. ADD SHT 3. ADD DETAIL J. SECTION F-F. ADD D3520-1. SCALE ON VIEWS WAS 3X.	AJS	17.03.27
D	D3304-1 WAS D2973; REVISE BOM & SECTION F-F & SECTION NOTES (2N B7-3, A2-3); REF NCR16-6180	RF	17.01.09
C	D3482 PLUG ASSEMBLIES REMOVED. REFORMAT NOTES SHT 1	AP	15.11.02
B	28.38 WAS 28.37 (2N C2-1). INCORPORATED DEO D3582-A-1 (2N D5-1). FORMAT TO CURRENT STD	RF	15.02.20
A	NEW ISSUE	PH	07.08.08
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	AJS		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	17.03.27		
DART AEROSPACE USA, INC EUGENE, OR			
DRAWING NO. D3582			
TITLE			
BK 117 SKIDTUBE ASSEMBLY			
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DETAIL C
SCALE 4X

SECTION D-D
SCALE 4X

SECTION E-E
SCALE 4X

SECTION D-D NOTES

SECTION D40 NOTES

PERFORM THE FOLLOWING:

1. CHAMFER HOLE 0.030 x 45°
2. INSERT D2971 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. PASS Ø0.750 DRILL TO REMOVE SPILL OVER

SECTION E-E NOTES

SECTION E-NOTES

AFTER DRINKING THE COFFEE, PERFORM THE FOLLOWING:

1. CHAMFER HOLE 0.030 x 45°
2. INSERT D3662-3 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. PASS Ø0.872 DRILL TO REMOVE SPILL OVER

SECTION F-F
SCALE 4X

SECTION G-G
SCALE 4X

DETAIL H
SCALE 4X

SECTION F-F NOTES:

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AFTER BENDING AND DURING PERFORM THE FOLLOWING:

1. INSERT D6304-1 SPACER
2. SWAGE TO Ø0.565 +0.005/-0.000 X 1.0
DEEP PER QS1 002
3. OPEN THRU HOLE TO Ø0.625
4. GRIND FLUSH

SECTION G-G NOTES

SECTION 600 NOTES

PERFORM THE FOLLOWING:

1. CHAMFER HOLE 0.030 x 45°
2. INSERT D3862-1 SPACER (3 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. PASS Ø0.515 DRILL TO REMOVE SPILL

DATE	17.03.27	DESIGN	PH	DART AEROSPACE USA, INC	
		DRAWN	AJS	EUGENE, OR	REV. E
		CHECKED	<i>MS</i>	DRAWING NO.	SHEET 3 OF 4
		MFG. APRR.		D3582	SCALE
		APPROVED		TTK 117 SKIDTUBE ASSEMBLY	NTS
		DE APRR.			

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 WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

RELEASED
2017-08-11

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

Job: _____ Part No. _____	DISPOSITION Rework ☐ ☐ Scrap ☐ ☐ Use-as-is ☐ ☐	DEPARTMENT/PROCESS Cross tube ☐ ☐ Small Fab ☐ ☐ Finishing ☐ ☐ Skid-tube ☐ ☐ Machining ☐ ☐ Large Fab ☐ ☐ Eng. (Non-AW) ☐ ☐ Prod. Eng. Coord. ☐ ☐ Rec/Store/Packaging ☐ ☐ Engineering ☐ ☐ Water Jet ☐ ☐ Supplier ☐ ☐ Quality ☐ ☐	MRB (QS1042)	Completed By Lead hand / Supervisor QC / QA Coordinator																																																																																																												
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